

**Work Order ID 56236**

Wednesday, February 17, 2010 10:06:44 AM



Page 1

Item ID: D412-769-042

Accept



Setup Start



Revision ID:

Item Name: Aft Facing Seat, RH

Stop



Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-2-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Pick Kit	10-6-7 sf
IIN D412-769	Rev B		

100	DOCUMENT CONTROL	0.00	10/06/07
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DC	Memo	0.00	10/06/07
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Document Control	Photocopy bluefile & type labels per PPP D412-769-042	CHG 001	10/06/07
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110	QC4- 100% Inspect kits for completeness	0.00	10/06/07
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QC	Memo	0.00	10/06/07
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Quality Control			10/06/07
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120	Packaging	0.00	10/06/07
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Packaging	Memo	0.00	10/06/07
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Packaging	Identify and pack for shipping as per PPP D412-769-042	Location: <u>15</u>	PPP Rev: <u>15</u>
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10/06/07

10/06/07

10/06/07

10-6-8 sf Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56236**

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Wednesday, February 17, 2010 10:06:44 AM

Item ID: D412-769-042

Accept



Setup Start



Revision ID:

Item Name: Aft Facing Seat, RH

Stop



Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/06/08 JJ

10-6-08  
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng /+ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Picklist Print

*Wednesday, February 17, 2010 10:06:43 AM*

Page 1

**Work Order ID:** 56236



**Parent Item:** D412-769-042



**Parent Item Name:** Aft Facing Seat, RH

**Start Date:** 2/18/2010

**Required Date:** 3/3/2010

**Comments:** IPP rev A 08-07-17 new issue DD verified by:EC

**Start Qty:** 1.00

**Required Qty:** 1.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / + Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## 25.9 Parts List

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
1	1		D412-724-041	HEAD REST ASSY, CENTER
1	1		D3303-041	HEAD REST
1	1		D3304-041	TUBE ASSEMBLY
4	4		AN525-10R6	SCREW
1			D412-724-043	HEAD REST ASSY, LH
1			D3303-041	HEAD REST
1			D3304-043	TUBE ASSEMBLY
4			AN525-10R6	SCREW
1			D412-724-044	HEAD REST ASSY, RH
1			D3303-041	HEAD REST
1			D3304-044	TUBE ASSEMBLY
4			AN525-10R6	SCREW
1			D412-769-043	AFT FACING SEAT ASSEMBLY, LH
1			D412-769-044	AFT FACING SEAT ASSEMBLY, RH
2	2		D3782-045	BACK LEG ASSEMBLY
1	1		D3772-1	BACK LEG
1	1		D3786-1	SLEEVE
1	1		D3787-1	FOOT
1	1		D3764-1	BACK LEG ADAPTER
1	1		D3773-041	HEAD REST ADAPTER
1	1		AN5-15A	BOLT
1	1		AN45-15A	EYE BOLT
1	1		AN5-17A	BOLT
2	2		AN4-15A	BOLT
4	4		NAS1149D0463J	WASHER
5	5		NAS1149D0568J	WASHER
2	2		MS21042L4	NUT
3	3		MS21042L5	NUT
1	1		D3782-041	FRONT INBOARD LEG ASSEMBLY
1	1		D3768-1	FRONT INBOARD LEG
1	1		D3762-041	FRONT LEG FITTING ASSY
1	1		D3787-1	FOOT
1	1		AN5-13A	BOLT
3	3		NAS1149D0568J	WASHER
2	2		MS21042L5	NUT
1	1		AN45-13A	EYE BOLT
1			D3782-043	FRONT OUTBOARD LEG ASSEMBLY, LH
1			D3768-3	FRONT OUTBOARD LEG, LH
1			D3762-041	FRONT LEG FITTING ASSY
1			D3787-1	FOOT
2			AN45-13A	EYE BOLT
2			NAS1149D0568J	WASHER
2			MS21042L5	NUT

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25-00-00

Revision: 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -011	Qty -041	Qty -042	Part Number	Description
	1		D3782-044	FRONT OUTBOARD LEG ASSEMBLY, RH
	1		D3768-4	FRONT OUTBOARD LEG, RH
	1		D3762-041	FRONT LEG FITTING
	1		D3787-1	FOOT
	2		AN45-13A	EYE BOLT
	2		NAS1149D0568J	WASHER
	2		MS21042L5	NUT
	1	1	D3783-041	LATERAL BRACE ASSEMBLY
	1	1	D3769-1	TUBE
	2	2	D3765-1	CLEVIS
	2	2	AN5-13A	BOLT
	4	4	NAS1149D0568J	WASHER
	2	2	MS21042L5	NUT
	2	2	D3783-043	LONGITUDINAL BRACE ASSEMBLY
	1	1	D3769-3	TUBE
	1	1	D3765-1	CLEVIS
	1	1	AN5-13A	BOLT
	2	2	NAS1149D0568J	WASHER
	1	1	MS21042L5	NUT
	1	1	D3783-045	ANGLE BRACE ASSEMBLY
	1	1	D3769-5	TUBE
	2	2	D3765-1	CLEVIS
	2	2	AN5-13A	BOLT
	4	4	NAS1149D0568J	WASHER
	2	2	MS21042L5	NUT
	1	1	D3784-041	SEAT SUPPORT ASSEMBLY
	1	1	D3770-1	TUBE
	1	1	D3763-041	END FITTING ASSY
	1	1	D3763-045	END FITTING ASSY
	2	2	AN525-10R20	SCREW
	4	4	NAS1149D0332J	WASHER
	2	2	MS21042L3	NUT
	1	1	D3784-043	SEAT SUPPORT, LH
	1	1	D3762-043	END FITTING ASSY, LH
	1	1	D3770-1	TUBE
	1	1	D3770-3	TUBE
	2	2	D3763-041	END FITTING ASSY
	4	4	AN525-10R20	SCREW
	4	4	NAS1149D0332J	WASHER
	4	4	MS21042L3	NUT
	1	1	D3784-044	SEAT SUPPORT, RH
	1	1	D3762-044	END FITTING ASSY, RH
	1	1	D3770-1	TUBE
	1	1	D3770-3	TUBE
	2	2	D3763-041	END FITTING ASSY
	4	4	AN525-10R20	SCREW
	4	4	MS21042L3	NUT
	8	8	NAS1149D0332J	WASHER

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25-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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REFERENCE ONLY

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Qty -011	Qty -041	Qty -042	Part Number	Description
	1		D3766-1	FRONT RAIL, LH
		1	D3766-2	FRONT RAIL, RH
1	1	1	D3766-3	REAR RAIL
1	1	1	D3767-1	UPPER RAIL
1	1		AN45-13A	EYE BOLT
6	6		AN5-10A	BOLT
2	2		AN5-13A	BOLT
20	20		NAS1149D0568J	WASHER
4	4		NAS1149D0463J	WASHER
12	12		MS21042L5	NUT
2	2		MS21042L4	NUT
28	28		MS21042L3	NUT
	2	2	AN4-15A	BOLT
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH
	1	1	D3774-1	SEAT BOTTOM
	1	1	D3774-3	SEAT BACK
13	13		AN525-10R22	SCREW
9	9		AN525-10R24	SCREW
21	21		NAS1149D0363J	WASHER
13	13		NAS1149D0332J	WASHER
6	6		AN3-5A	BOLT
2	2		D3775-1	GUARD
3	3		D3792.1	SEAT BELT EYE BOLT

NOTE: . PART INCLUDED WITH ASSEMBLY ABOVE  
. PART INCLUDED WITH ASSEMBLY ABOVE  
. PART INCLUDED WITH ASSEMBLY ABOVE

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25-00-00

Revision: 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#### 4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011 Aft Facing Seat kit	60.0 lb 27.2 kg	0.0 in 0.0 m	0.00 in-lb 0.00 m-kg	87.0 in 2.21 m	5220 in-lb 60.11 m-kg
D412-769-041 Aft Facing Seat, LH (normal position)	30.0 lb 13.6 kg	-16.1 in -0.41 m	-483.0 in-lb -5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (normal position)	30.0 lb 13.6 kg	+16.1 in +0.41 m	+483.0 in-lb +5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (center position)	30.0 lb 13.6 kg	-1.1 in -0.03 m	-33.0 in-lb -0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (center position)	30.0 lb 13.6 kg	+1.1 in +0.03 m	+33.0 in-lb +0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (right Position)	30.0 lb 13.6 kg	+13.9 in +0.35 m	+417.0 in-lb +4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (left Position)	30.0 lb 13.6 kg	-13.9 in -0.35 m	-417.0 in-lb -4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg

#### 5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1	X		D412-769-042	AFT FACING SEAT, RH
1			D412-769-043	AFT FACING SEAT ASSEMBLY, LH
1			D412-769-044	AFT FACING SEAT ASSEMBLY, RH
1			D412-724-041	HEAD REST ASSEMBLY, CENTER
1			D412-724-043	HEAD REST ASSEMBLY, LH
1			D412-724-044	HEAD REST ASSEMBLY, RH

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Revision: C  
 Date: 09.11.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries